

SPUT

Work Order ID 55108-2



Page 1

January 6, 2010 11:48:16 AM

Item ID: D2807-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Door prop

11

Start Date: 1/06/10

Start Qty: 20.00



Cust Item ID:

Required Date: 1/20/10

Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL

Date: 10/01/06 Tooling:

Date:

Stop



QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2807

Rev E

100



Purchasing

Purchasing

PURCHASING

0.00

Memo

0.00

Issue P/O: 11045 Order as per Dwg D2807 Possible
supplier: Lift Support Technologies, Saskatoon, Canada P/N 6/15-164/50-115N

Material release note is required

CL 10/01/06 20

110



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Ensure Material Release Note is attached

CL 10/01/12 20

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

All parts of 35-85 lbs of
Memo face

0.00

→ S. L. L. 13

center
(720)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab Small Fab	Small Fab Memo 1-install D3671-1 as per dwg D2807	0.00 0.00	<i>2/10/12</i> <i>11X</i> <i>2/10/01/27</i> <i>9</i>						
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
150 Packaging Packaging	Identify as per dwg & Stock Location: <i>26</i> Memo	0.00 0.00	<i>=> Start 10/02/02</i> <i>410</i>						

2/10/13 *11*

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Page 3

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Setup Start



Revision ID:

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Item Name: Door prop

Start Date: 1/06/10

Start Qty: 20.00



Cust Item ID:

Required Date: 1/20/10

Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/03

MF

10-2-3

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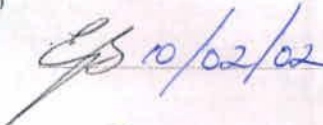




NOTE: Date & initial all entries

January 6, 2010 11:48:15 AM

Comments:

Required Date: 1/20/10

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3671-1  Placard		Manufactured	No			110	Each	9.0000	20.0000 		10/02/02 	
				<u>Warehouse</u> <u>Location</u> Main Warehouse ST								
					50174							
6/15-164/50-115N  Gas Spring		Purchased	No			130	Each	0.0000	20.0000 		 10/02/02 855650 (11X) 	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

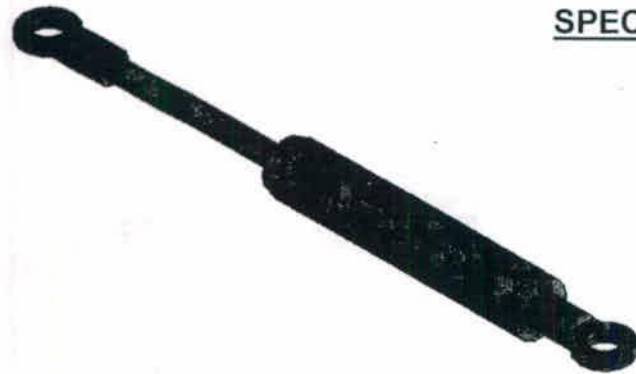
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SPECIFICATION CONTROL DRAWING



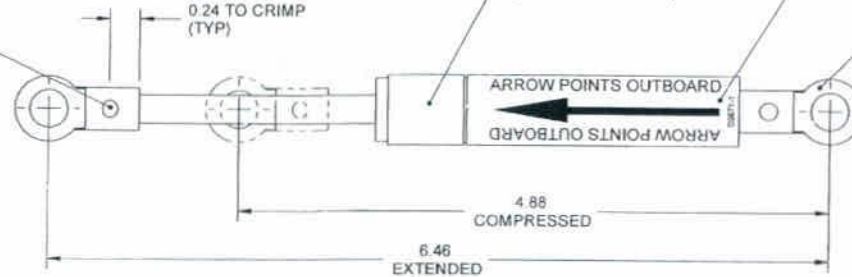
(ALTERNATE ONLY)
CRIMP 0.015-0.025 DEEP
WITH $\phi 0.375$ TOOL AT
2000psi (REF) TYP TWO
SIDES PER LUG

0.24 TO CRIMP
(TYP)

D2807-5
OR
(ALTERNATE ONLY) D2807-1

AFFIX D3671-1 PLACARD
ENSURE PLACARD DOES NOT
CONCEAL ANY TEXT OR MARKINGS
ON THE GAS SPRING

(ALTERNATE ONLY) D2807-3
BOTH ENDS



D2807-041 GAS SPRING

D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2)
(WEIGHT: 0.176 LBS)

*(21010104
W10:55108)*

DESIGN	ADD D2807-5 GAS SPRING; D2807-1/-3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
DRAWN	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
CHECKED	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
MFG. APPR.	ADD FINISH	CP	05.03.16
APPROVED	NEW ISSUE	DS	00.11.03
DE APPR.	REV. DESCRIPTION	BY	DATE
DATE	07.12.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D2807
REV. E
SHEET 1 OF 3
TITLE
GAS SPRING
SCALE
NTS

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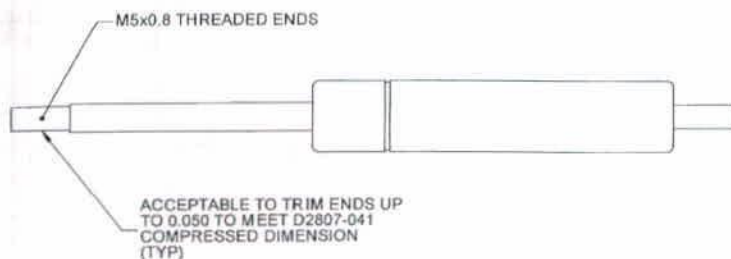
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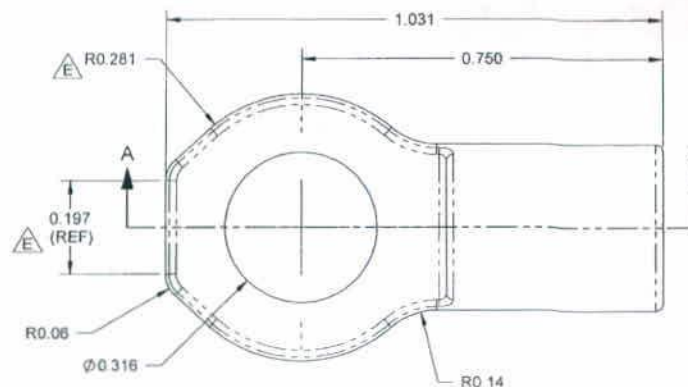
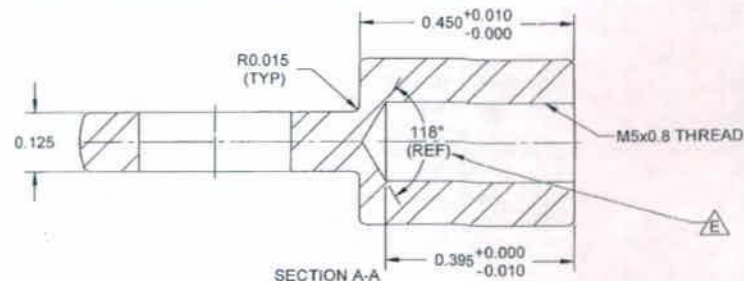
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D2807-1 GAS SPRING
SCALE 1:1



D2807-3 LUG

D2807-1 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK
(P/N SXF6S605008056L-115N)
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX
M5x0.8 THREADS

D2807-3 LUG NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR (REF: DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS

55108

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2807	REV E
MFG. APPR		TITLE GAS SPRING	SHEET 2 OF 3
APPROVED		SCALE 4:1	
DE APPR		COPYRIGHT © 2000 BY DART AEROSPACE LTD	
DATE	07.12.28	THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED ONLY FOR THE PURPOSES SPECIFIED AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

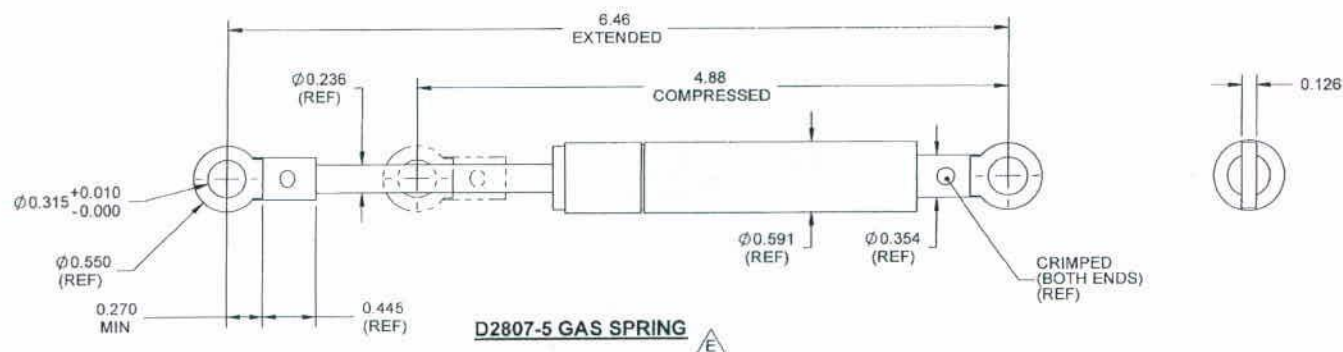
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D2807-5 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA
(P/N 6/15-164/50-115N)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS,
ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	DRAWING NO.	REV. E
MFG. APPR.		D2807	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GAS SPRING	4:1
DATE	07.12.28	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

55108

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO11045

Purchase Order Date 1/06/10

PO Print Date 1/06/10

Page Number 1 of 1

Order From :

VC-LST0001

LS TECHNOLOGIES INC.
303-103 STREET
SASKATOON, SK S7N 1Y9
CA

FAKED
Circled stamp

Contact Name
Vendor Phone 306 683 5000
Vendor Fax 306 683 6403
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extend Pr
1	6/15-164/50-115N	Gas Spring	1/20/10 Yes	20.00 Each	FedEx PI ppd	\$63.9000	\$1,278

Special Inst: AS PER DWG D2807 REV. E
B55108
LS TECHNOLOGIES P/N: 6/15-164/50-
115N

PO Total: \$1,278

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 1/06/10

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

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303 - 103rd Street, Saskatoon, Saskatchewan, Canada S7N 1Y9
Ph: (306) 683-5000 Fax: (306) 683-6403
E-mail: lstech@lsttechnologies.ca www.liftsupporttechnologies.com

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

20 Units: D2807 - 6/15-050-164-115N Stainless Gas Spring

Country of Manufacture: Canada

Date of Manufacture : Jan 2010

This product is ROHS compliant.

We certify no mercury was used in the manufacture of this order.

Purchase Order # 11045

Invoice # 5650

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to read "Nolan Fehr".

Nolan Fehr
Manager

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